

Work Order ID 72404

Monday, July 25, 2011 10:57:41 AM

SHIP TUESDAY



Page 1

Item ID: D3074-1

Revision ID:

Item Name: Arm

Start Date: 7/25/2011 Start Qty: 1.00

Required Date: 7/27/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3074

Rev

W/R OK TO PROCEED FOR MAKE UPS

0.00

100



Small Fab

Small Fab

Memo

Make part as per Dwg D3074 Deburr

0.00

Small Fab

Bond 11/07/26

Drill hole 11-07-26

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

11/07/26 11-07-26 AS per Attached Dwg

Memo

0.00

120



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

11/3/28

Memo

0.00

START TIME:

1:00

OVEN TEMPERATURE:

300 FINISH TIME:

1:20

1 BR 11-7-26

PTO

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3074-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: SCRAP QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/07/26	100	MIRROR DIDN'T FIT WHEN TRYING TO INSTALL. INTERFERENCE. P.C. DEVELOPMENT / PROTOTYPE	11/07/26 CSLOAR	SCRAP + REPLACE BY PROVIDING ENOUGH CLEARANCE PER MARKERS ON Dwg. ID: H 115 010	SM 11/07/26	M/M 11/07/26	11/07/26	M/M 11-07-26

NOTE: Date & initial all entries

Work Order ID 72404

Monday, July 25, 2011 10:57:41 AM



Page 2

Item ID: D3074-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/26

11/7/26
Horse
D

Marc Bellavance

From: David Shepherd <dshepherd@dartaero.com>
Sent: July 22, 2011 9:27 PM
To: 'Marc Bellavance'
Cc: 'Bill Beckett'
Subject: RE: D3074-1 (ref. D119-696-011 Mirror)
Attachments: image001.png

I think we should send him an arm that is 3" shorter manufactured from 0.049" wall for him to try.
This can be done as a deviation on the work order.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: July-22-11 6:48 AM
To: Shepherd, David
Subject: D3074-1 (ref. D119-696-011 Mirror)


David,

Adam from Coordinates Capital Corporation called yesterday to complain about the A119 Cargo Mirror as follows:

- Shaft or Arm P/N D3074-1 keep on breaking at bolt location (of D2056 Bellcrank Assy). He went through 3 arms in 800 hours;
- Mirror is in his opinion poorly located and should be moved approximately 3in inboard.

In discussing the issue with Bill, it was agreed that we should provide him with a no charge replacement arm. I haven't check whether we have stock or not but assuming we didn't, drawing D3074 is under review. It has been since June 23rd, 2008 with a note saying that the wall thickness of the tubing should be increased from 0.035in to 0.049in. Manufacturing an arm will require engineering sign off on the W/O. Bill kicked the idea around that perhaps we should manufacture a custom D3074-1 that Adam could test for us which I think is a good idea/opportunity. What are your thoughts on this?



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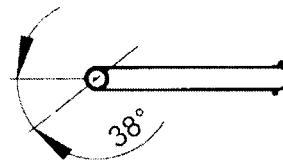
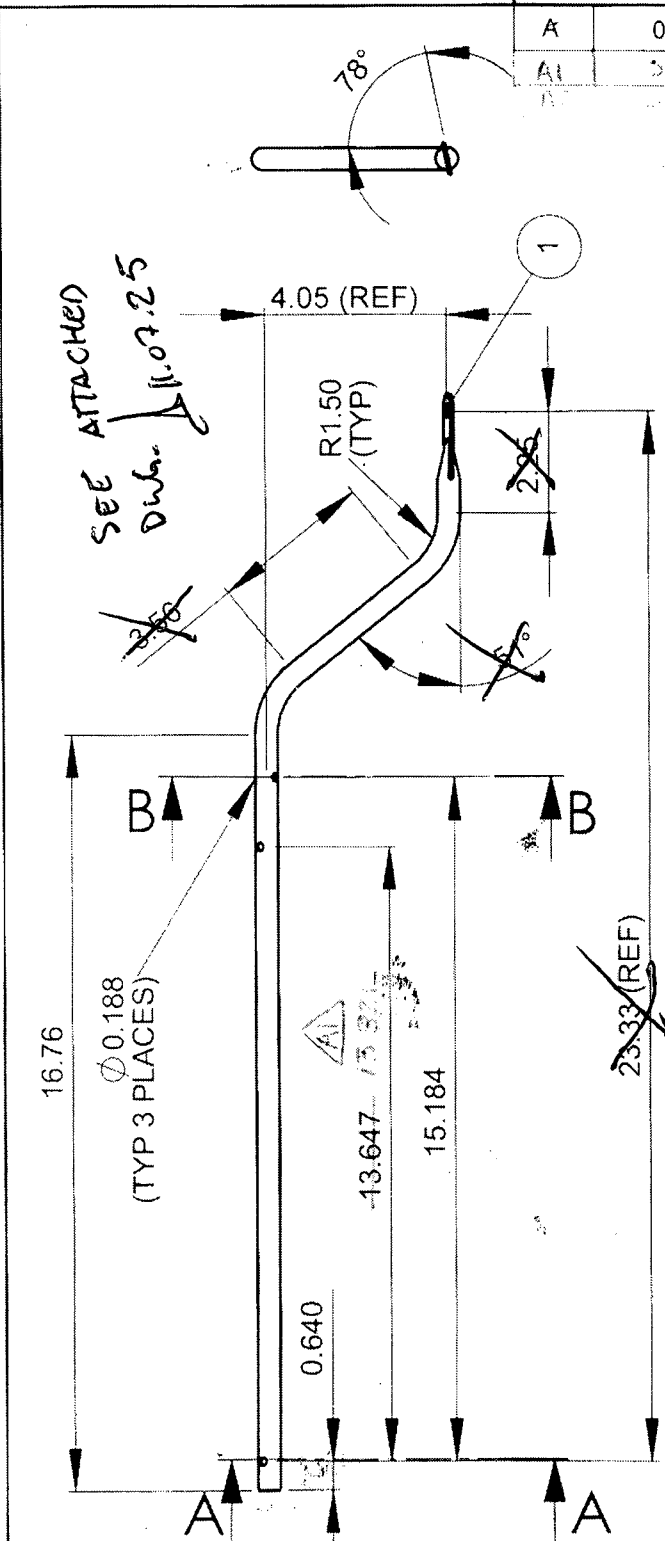
Marc Bellavance
Technical/Shop Support
Tel: 613-632-5200 Ext. 243
Cel: 613-676-0992
Fax: 613-632-9311

Product Documentation: Verify Revision Status/Download [HERE!](#)

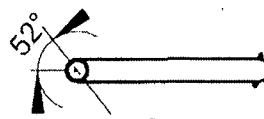
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3074	REV. A SHEET 1 OF 2
DATE 01.12.17		TITLE ARM	SCALE 1:4
A	01.12.17	NEW ISSUE	
AI	22.04.15	15.021 WAS 14.047 <i>CP</i>	
AI	22.04.15	ADD FINISH <i>CP</i>	



SECTION B-B
(1 PLACE)



SECTION A-A
(TYP 2 PLACES)

UNDER REVIEW
03.06.25 *CP*
CHANGE TO 0.049 WALL TUBING

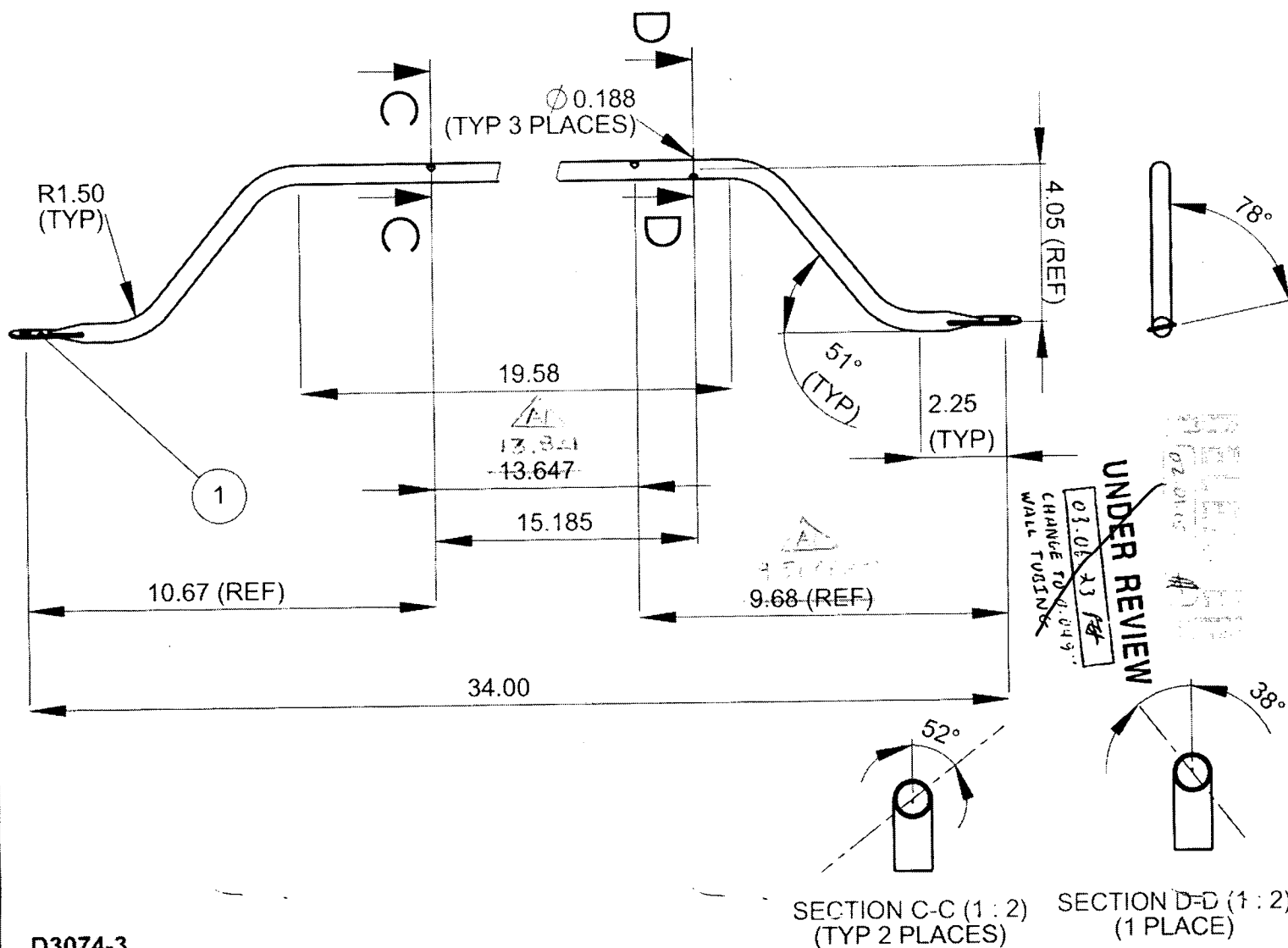
- 11.07.25*
0.049
- D3074-1**
- 1) PUNCH END PER SPEC CONTROL DRAWING D2727
 - 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.50 \times 0.049$ WALL
ENSURE SEAMLESS TUBING IS USED
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 2
DATE		DRAWING NO. D3074	SCALE 1:4
01.12.17		TITLE ARM	



D3074-3

- 1) PUNCH ENDS PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS NOT SYMMETRIC

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